Memo

0.00

Quality Control

108/28

120

QC8- Inspect parts - second check

0.00

Re 11 C. 2P

Memo

0.00

Quality Control

		<del></del>							
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date:	·
	Res	solution:	Disposition	];	QA: N/C C	losed:	·	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	₹)			
DATE	STEP	Description of NC		Corrective Action Section	on B Sign 8	<b>3</b>	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector
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### Work Order ID 71299

Page 2

Monday, June 27, 2011 2:45:10 PM

Item ID:

D3183-9

Accept

Setup Start



Stop

**Revision ID:** 

Item Name: **Start Date:** 

Cap

6/27/2011

**Start Qty: 20.00** Req'd Qty: 20.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Tooling:

Date:

Run

Start

Required Date: 6/27/2011

QC:

Date:

SPC (Y/N):

Tool ID

Date:

Stop

Sequence ID/ **Work Center ID** 

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool # Plan

Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/6/28 A)

Dart Aerospace	Ltd
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W/O:			WO	RK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	By	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		-								
Part No	:	PAR #:	Fault Categ	ory:	NCR: Y	es N	o DQ	A:	Date: _	
		solution:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC			tion B	O		ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		gn & late	Secti	on C	Chief Eng	QC Inspector
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# **Picklist Print**

Monday, June 27, 2011 2:45:06 PM

Work Order ID: 71299

Parent Item: D3183-9

Parent Item Name: Cap



Start Date: 6/27/2011

Required Date: 6/27/2011

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP A□ 06.05.03□ New issue□ KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No		100	f .	1.9070	0.0333	0.701053		,	
									_ \	11.	<	

Delrin Round Bar 1"

Location MAT055

Loc Qty 1.907 1.907 Loc Code

# **Dart Aerospace Ltd**

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W/O:			WC	RK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCR: Yes 1	No DQA:	Date: _	
		esolution:						
NCR:		\	WORK ORDI	ER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC			ion B	Verification	n Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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							}	
	1		1 1		1			1

13

DART AEROSPACE LTD	Work Order: チルフラ
Description:	Part Number: N 3 153-9
Inspection Dwg: 3/8 3 Rev: CI	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
276	±.010	-247			8.02	
-039	= 010	-040			/	
.830	010	.831				
- 420	I,002	. 120				
447	±-001	. 448				,
					<u> </u>	
	·					
						<i>A</i>

Measured by:	SI	Audited by:	R	Preliminary Approval:	
Date:	1116/28	Date:	11 - 6.28	Date:	

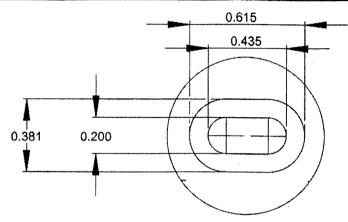
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15





	DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, C	
and the second second	CHECKED	APPROVED	D3183	REV. C SHEET 4 OF 4
	DATE 04.	02.17	BRACKET ASSEMBLY	SCALE 1:1

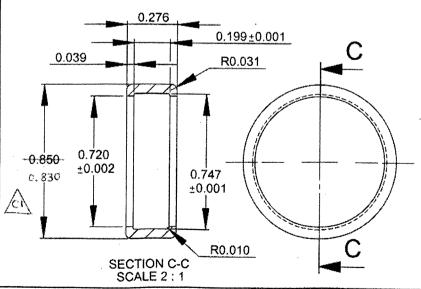


**DETAIL A (2:1)** 

DEO ATTACHED

**DETAIL B (20:1)** 

# 0.050 (TYP) 0.025 (TYP) 0.032



### D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00) 2) TOLERANCES ARE PER DARRY QSI 018
- **UNLESS OTHERWISE NOTED**
- 3) ALL DIMENSIONS ARE IN INCHES

# **D3183-045 BEARING ASSEMBLY**

1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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Dart	Aer	ospa	ce Ltd
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W/O:			WO	RK ORDER CHANGE	S			,	
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			,						
10.00									
		***************************************							
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	Res	solution:	Disposition: Q			osed:	Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	l)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verific	cation	on Approval	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
				CONTRACTOR OF THE CONTRACTOR O					
•									

<sup>▼</sup> H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DRAWING NO.	TITLE	<del></del> -	REV.C1	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO. SO	CALE
D3183	BRACKET	ASSEMBLY		<b>ENGINEERING ORDER</b>		SHEET 1 OF 1	NTS
DRAWN	P	CHECKED	基	MFG. APPR.	APPROVED AN	DE APPR.	
DATE 10	0.05.14	DATE /	0.06.30	DATE (8.06.30	DATE 10/06/30	DATE 10/06/30	$\overline{}$

### **D3183-5 BEARING**

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

**BASIC LOAD RATING REQUIREMENT:** 

Cr = 1720 N (386 lb) MIN [DYNAMIC]

Cor = 840 N (188 lb) MIN [STATIC]

**REF PAR 10-012** 

#71299



# **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHANG	GES					·-· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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			<i>III</i>						_,		
Part No:PAR #:		PAR #:	Fault Category:NC			CR: Yes No DQA: Date:					
Resolution:			Disposition: Q/			N/C Clo	sed:	Date:			
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verificati		ation	on Approval	Approval	
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